

The Applicant wishes to amend the above-noted application as follows:

IN THE CLAIMS

Please cancel claims 2, 6 - 13, 18 - 23, 27 - 31, and 35 - 67, and amend claims 1-5, 14-18, 24-26 and 32-34. A replacement claim set is submitted herewith.

IN THE DRAWINGS

Please replace Figures 1 to 8 and 21 to 23 currently of record with the substitute drawings submitted herewith, showing the changes made.

IN THE SPECIFICATION

Please replace pages 27- 30 and 33-38 with amended pages submitted herewith, showing the changes made.

REMARKS

An amended version of the claims illustrating the changes made and the cancelled claims is provided herewith. Amended specification pages and drawings are provided. The Power of Attorney form establishes the right of the agent to act on behalf of the applicant.

The requisite Fee Transmittal Form PTO/SB/17 (01-03) and accompanying fee is submitted herewith. Any other fee required to maintain the application in good standing should be debited from Deposit Account No. 501593.

Each objection raised in Paper No. 10 is dealt with sequentially herein.

In Paragraphs 2 and 3, the Examiner again asserts the restriction requirement. Thus, in response, the Applicant wishes to cancel claims 6-13, 19-23, 27-31, and 35-67, and to proceed only with claims 1, 3 - 5, 14 - 17, 24 - 26, and 32 - 34. Claims 2 and 18 have been cancelled.

SPECIFICATION AND DRAWINGS

In Paragraph 5, the Examiner raises objections to the disclosure on the basis of certain informalities, each of which is addressed below.

(i) On pages 27 and 28, regarding reference numeral 116, the applicant advises that this reference numeral correctly identifies "projecting ends" on page 28 (line 16), and thus has been deleted from page 27 (line 30). The rear edge discussed on page 27 (line 30) is no longer referred to by reference numeral, but it would be clear to one skilled in the art that the rear edge is opposite the front edge, identified as reference numeral 115.

(ii) On pages 28 and 29, regarding reference numeral 900, the "grid oriented cylinders" are now appropriately referred to as reference numeral 3700 on page 29 (line 3). Thus, page 28 (line 8) correctly refers to 900 as a centre line clamp.

(iii) On page 37, numeral 1753 has been corrected to read 1704 on page 37 (line 2); numeral 1705 has been corrected to read 1752 (line 4) and FIG. 17 has been corrected to read FIG. 15 (line 17).

These pages 27, 29 and 37 have been corrected, and replacement pages are submitted herewith in their entirety.

In Paragraph 6, the Examiner has requested that the Applicant co-operate in identifying and correcting minor errors in the specification of which he is aware. To this end, the Applicant has amended page 36 (line 12) to now refer to FIGS. 14 to 17 (instead of FIGS 17 to 20).

Please be advised that the Applicant has not independently identified other errors in the specification, but would be happy to review any specific passage or pages of concern to the Examiner, if so advised more particularly.

In Paragraph 7, the Examiner has objected to the drawings for failing to refer to reference numerals 600, 1200, 708, 917, 205, 1050.

To remedy this situation and traverse the objection, the Applicant has amended so that the "female blanking die 600" reference on page 28 at lines 22 and 30 now refers to "female blanking die 300", consistent with figure 3, as well as with the specification, for example at page 30 (line 4). Reference numeral 600 had been included by error.

Reference numeral 1200 (grid orientation brackets), can now be found on FIG. 3. Reference numeral 1200 had been omitted in error.

Reference numeral 708 now appears on FIG. 7 (in place of reference numeral 120, which had been included in error) to appropriately indicate "centre line 708".

Reference indicator 917 has now been included on FIG. 1 in two places to illustrate the upper flange 917 for both front rail 201 and rear rail 202. This had been left out in error.

Reference numeral 205 has now been included on FIG. 1 with respect to the rear rail 202, and the indicator number previously shown as 210 on the front rail 210 has now been amended to read 205, since groove 210 can be used to reference grooves in the side rails (203 and 204), such as on page 28, line 6. Page 28, line 3 has also been amended to refer to internal dovetail grooves 205 and 210. An analogous amendment has been effected on FIG. 2.

Reference numeral 1050 formerly found at page 36, line 14 has been changed to read "1750" to appropriately indicate the lower "L"-shaped component. This is supported by line 20 of page 36. Numeral 1050 was included by error.

In Paragraph 8, the Examiner has objected to the drawings because they include reference numerals not mentioned in the description. Particularly:

(a) 207 and 108 (FIG. 1): Numeral 207 has been deleted in the upper left-hand side occurrence to indicate 1701 (the upper "L"-shaped component, as supported by Figure 15, for

example. Numeral 207 has been deleted in its second occurrence (upper right-hand side) to refer to bolt 208, as supported by both Figure 1 and Figure 14 (and page 28, line 25). Reference numeral 108 has been deleted from FIG. 1, as it was erroneously included, and is redundant in view of indicator number 100.

(b) 131, 1500, and 3700 (FIG. 2): Reference numeral 131 was erroneously included and has been corrected to read 2600, consistent with Figure 3 (and page 29, line 24). Reference numeral 1500 has been corrected to read 3400, consistent with Figure 3 (and page 29, line 29). As discussed above with reference to Paragraph 5 (ii) of the Office Action, reference numeral 3700 is now appropriately referred to on page 29 (line 3).

(c) 2900 (FIG. 3) has been replaced with 3100 to represent "jogger members" as indicated in FIGS 29 and 30. This error was inadvertent.

(d) 1774 (FIG. 14) has been replaced with 1754, consistent with Figure 15. This was a mere typographical error.

In Paragraph 9, the Examiner has objected to the drawings because the reference numerals "2300" and "2900" appear to designate both side and rear jogger members. This has been remedied because in Figure 3, reference numeral 3100 is now used in place of 2900. It should now be clear that Fig. 21 (2300) refers to side/rear jogger members, while Fig. 29 refers to jogger member 3100.

Reference numeral 400 is used correctly in Figs. 1 and 2, but erroneously in FIG. 7. Thus, Fig. 7 has been corrected to read 100 instead of 400 (consistent with FIG. 1).

Reference numeral 402 has been corrected on FIG. 2 to read "3302" consistent with Figure 31, and page 45, line 18, which refers to the lower vertical leg 3302 for the grid support bracket 3300.

In FIG. 2, reference numeral 403 has been corrected to read 405, consistent with the other indicator numeral 405 used in FIG. 2. On page 33 (line 30), the depending arm block is now designated 8403, and this change has also been made consistently with FIGs 4, 5 and 6.

Similarly, hole 404 of FIG. 4, as noted on page 34 is now referred to as "8404" to distinguish from component 404 of FIG. 2. Page 34 has also been amended so that 8404 (and 408) refer consistently to holes while 407 refers specifically to a bolt, consistent with FIGs 4 to 6.

Reference numeral 404 now specifically defines a grid (as per page 29, line 10), but not a hole or bolt. Reference numeral 405 is now used consistently to define grid rails as in FIG. 2, but not a front face, which is now referred to as 8405 in FIG. 4, and on page 34, line 2.

Reference numeral 700 previously found on page 28 now instead refers to "rail connector elements 400" to correct the error. Numeral 700 now correctly identifies only centre line orientation cylinders, as referenced in FIGs 7 and 8.

Reference numeral 905 has been deleted from line 16 of page 35, to delete the incorrect occurrence of this number.

Reference numeral 1752 has been deleted from line 29 of page 36, to delete the incorrect occurrence of this number.

Reference numeral 2311 has been deleted from line 19 of page 38 to traverse the Examiner's objection. However, it is noted that in this occurrence bolt 2315 is now indicated as an Allen-head bolt, consistent with Fig. 21.

Regarding reference numeral 2323, it is now clear from page 38 that this reference numeral refers to the inner wall, and the inner face of that wall does not require a reference numeral. Thus, the occurrence of 2323 on line 25 of that page has been deleted.

Regarding Paragraph 10, reference to bolts 108 has been corrected to read 208 on page 30, line 4. The objection raised to the use of both 3300 and 1200 to represent grid orientation brackets has been traversed, now that grid orientation brackets 1200 are shown on FIG. 3, which are distinct from those numbered as 3300 on FIG. 3.

The auxiliary support members now shown on FIG. 2 are numbered as 3400, while reference to 3600 on page 30 has been changed to 3400. Cylindrical rod 105 is now referred to consistently, while page 35 has been amended to refer to rod 105 and cradle 907 on line 20.

It is now clarified that 205 and 210 both define dovetail grooves, so this is not contradictory. Reference to 1050 has been removed from page 36. Fig. 14 has now been amended so that 1774 is now 1754. Thus, all objections raised in Paragraph 10 are traversed.

CLAIMS

With respect to the claim rejections, the Applicant has revised the remaining claims of the application have been amended to remove phrases that lack clear antecedent basis in claims 1, 5, 14, 15, 17, 24, 25, 32, and 33. Claims 2 and 18 have also been cancelled because the features recited in these claims were not features of the jogger member itself.

Further, the objection that claim 1 is vague has been traversed by improving the claim language.

Additionally, claim 3 has been revised to improve the claim language. Claim 4 has removed the phrase "it". All other claims referring to "it" or "its" have been amended for clarity. Additionally, in claim 16, and 26 the term "slot" has been clarified. A number of terms in the claims which had previously incorporated the term "means" have been revised. For example "slidable captive cap means" has been replaced with "a slidable captive cap".

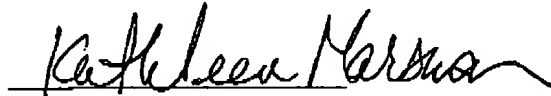
Those claims which make reference to connecting rails now only do so to assist in providing context and antecedent for those features of the jogger member which interact with the rails. However, the rails themselves are not considered part of the jogger member itself.

The Applicant believes that no new matter has been introduced with this amendment, and assures that every attempt was made to identify problems with the specification to amend at this time. However, the Applicant and Agent will continue to review the specification for errors, and may thus follow up this submission with a supplemental submission to correct any outstanding errors.

It is believed that the amendment effected herein should render the claims of this application allowable. If there are any outstanding matters, the Applicant requests that the Examiner contact the Agent of Record directly by telephone at (613) 787-3572 (Kathleen Marsman) to discuss such matters.

Respectfully submitted.

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Enclosures

1. Fee Transmittal Sheet
2. Power of Attorney
3. Revocation and Appointment of Agent
4. Specification Pages 27-30 and 33-38
5. Figures 1 to 8 and 21 to 23
6. Claims 1, 3-5, 14-17, 24-26 and 32-34.

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FIG. 34 is a view of the assembly of various elements to the dovetail groove in the rails;

FIGS. 35 and 36 are views of one embodiment of a grid orientation cylinder, in which:

5 FIG. 35 is a perspective view of a grid orientation cylinder which is about to be inserted into a "T"-nut which is secured within an aperture in the template, and

FIG. 36 is an elevational view thereof.

(f) AT LEAST ONE MODE FOR CARRYING OUT THE INVENTION

10 While the erection of the female blanking die is not claimed in the present invention, it being the subject of co-pending application Se. No. (our file DIEX 009), a brief description thereof will be provided with respect to FIGS. 1 to 3.

As seen in FIG. 1, a template 100 is provided within a universal press frame 200. The template 100 has a peripheral outline 101 which coincides with, but is slightly larger than, the periphery of a plurality of abutting cartons which have been die cut from a
15 sheet. The template 100 is also provided with a plurality of generally-rectangular holes 102, below which are a plurality of foam plastic blocks 103 which are removably-secured to the bottom surface thereof.

The template 100 is provided with a plurality of apertures within which are secured "T"-nuts. One series of such apertures are two centre line apertures. A centre
20 line orientation cylinder 106, to be fully-disclosed hereinafter, is removably-secured in each of these "T"-nuts in these apertures. The through bores 107 in the centre line orientation cylinders 106 are aligned, and a centre line cylindrical rod 105 is urged therethrough.

The upper surface of the template 100 is provided with a lasered outline 110
25 which coincides with the inner abutted edges of the plurality of cartons which have been blanked from a sheet. A second set of apertures 111 is placed strategically along that lasered outline 110. These apertures are each also fitted with "T"-nuts.

A third set of such apertures 112 comprises four apertures, two of which are placed along each of the side edges 113, 114 of the template 100, adjacent to the front
30 edge 115 and to the rear edge ~~116~~. This set of apertures 112 is also fitted with "T"-nuts.

The universal press frame 200 is constituted by a front rail 201, a rear rail 202, and two side rails 203,204. Each such rail is provided with a internal dovetail groove 205 and 210. The side rails 203,204 are each secured at right angles to the front rail 201 and to the rear rail 202, by means of four rail ~~clamps 700~~ ^{connector elements 400}. The rail ~~clamps 700~~ ^{connector elements 400} are secured to rails by means of suitable bolts, which are threaded into trapezoidal nuts which are placed in the internal dovetail groove 210 in the rails. These rail ~~clamps 700~~ ^{connector elements 400} will be described in greater detail hereinafter.

Centre line clamps 900 have been placed on the front rail 201 and on the rear rail 202. These centre line clamps 900 have been secured at the precise centre point which has been marked on the front rail 201 and on the rear rail 202. These centre line clamps 900 will be described in greater detail hereinafter.

Legs 2100 have been secured onto the universal press frame 200, namely two on the front rail 201 and two on the rear rail 202. These legs 2100 will be described hereinafter.

It is seen that the template has been placed within the universal press frame 200 by having the projecting ends 116 of the centre line cylindrical rod 105 rest on the cradles which are provided in the centre line clamps 900. The template 100 is, thus, placed exactly within the center of the universal press frame 200 in such a manner that it cannot be moved transversely, but it can be moved longitudinally. Four template corner clamps 1700 have been secured, two to each of the side rails 203,204, at the precise points on those rails which have been defined by a CAD program, to place the template 100 in the exact position for the erection of the female blanking die ~~600~~ ³⁰⁰. These template corner clamps 1700 will be described hereinafter. The template 100 has been moved longitudinally so that the third set of apertures 112 in the template 100 are aligned with the slots in the template corner clamps 1700. Then, suitable bolts 208, e.g., Allen-head bolts, have been inserted through the slots in the template corner clamps 1700, to secure the template 100 in the exact position, as required by the CAD program, within the universal press frame 200. The intermediate structure so-provided is rigid, and is perfectly square and since the template 100 is perfectly sited within the universal press frame 200, it can be used as the basis for the erection of the female blanking die ~~600~~ ²⁰⁰.

As seen in FIG. 2, since the template 100 has been accurately and rigidly-fixed within the universal press frame 200, the centre line clamps 900, the centre line cylindrical rod 105 and the centre line orientation cylinders 106 are no longer required. Consequently, the centre line cylindrical rod 105 is removed, the centre line orientation cylinders 106 are unscrewed from the "T"-nuts in the template 100, and the centre line clamps 900 have been removed from the rails 201,202.

A plurality of grid orientation brackets 3300 (which will be described hereinafter) have been placed loosely along the perimeter of the universal press frame 200. A plurality of grid orientation cylinders ~~900~~³⁷⁰⁰ (which will be described hereinafter) have been placed in the second set of "T"-nut-fitted apertures 111. This enables a grid 404, which is shaped to coincide exactly with the inner abutted edges of the plurality of cartons which have been blanked from a sheet, to be placed with its grid rails 405 within the upper aligned grooves in the grid orientation cylinders 900 and on the grid orientation brackets 3300. The grid orientation brackets 3300 have been slid along the respective rail to enable engagement with the grid rails 405 and are locked in that position on the respective rails. The grid has, thereby, been locked into place in the exact position, as defined by the CAD program, within the universal press frame 200.

As seen in FIG. 3, a plurality of side rail jogger members and rear rail jogger members 2300 (which will be described hereinafter) have been secured at selected positions to the side rails 203,204 and rear rail 202. They have been adjusted so that the guiding surface abutted selected portions of the side and rear edges of the template 100, and so that the slidable caps thereof were slightly further into the central area of the universal press frame 200, than the guiding surfaces thereof.

A plurality of front rail jogger members 2600 (which will be described hereinafter) have been secured at selected positions to the front rail 201. They have been adjusted so that the guiding surface abutted selected portions of the front edge of the template 100, and so that the slidable caps thereof were slightly further into the central area of the universal press frame 200, than the guiding surfaces thereof.

A plurality of auxiliary support members 3400 (which will be described hereinafter) have been secured at selected positions to the rails 202,203,204. They have

been adjusted so that the slidably-adjustable table thereof extended slightly further into the central area of the universal press frame 200, than the respective peripheral edges of the template 100.

FIG. 3 shows the finally-erected female blanking die 300. The suitable bolts ²⁰⁸~~108~~, e.g., Allen-head bolts, holding the template 100 to the template corner clamps 1700 have been removed, which allowed the template 100 to fall below the universal press frame 200 to the level which was defined by the bottom of the legs 2100. The grid orientation cylinders 900 have been removed from the template 100. In addition, the template corner clamps 1700 have been removed from the side rails 203,204.

This female blanking die 300, thus, comprises the universal press frame 200, to which are secured the grid orientation brackets 1200 which secure the grid 404 to the universal press frame 200. The universal press frame 200 is fitted with the plurality of side and rear rail jogger members 2300, the plurality of front rail jogger members 2600 and the plurality of auxiliary support members ~~3600~~ ³⁴⁰⁰. It is noted that the legs 2100 have been removed.

To recapitulate the above-detailed description in narrative form, a universal press frame is assembled as a rectangular framework of two side rails, a front rail and a rear rail. Each rail includes an internal dovetail groove. The side rails are preferably sited at a higher vertical level than the front rail and the rear rail.

The four template corner clamps are secured to the side rails, i.e., two on each side rail adjacent to the front rail and to the rear rail, situated on the side rails at particular data points which have been defined by a CAD program to dispose a template in the exact location within the universal press frame.

Then a centre line bracket is mounted on each of the front rail and of the rear rail, at the precise centre point of such rails.

A template, whose perimetrical shape coincides with the outer peripheries of a plurality of cartons which are to be blanked from a sheet, is however, slightly larger than those peripheries. The template is also provided with a centre line which is laser-etched thereon, and with a front centre line aperture and a rear centre line aperture on the lasered centre line. These centre line apertures are each fitted with a "T"-nut. The

to the stripping station. At the stripping station, much of the excess and the surplus material on the stamped sheet is removed. However, the die-cut blanks are held together by a thin wall or "nick". After stripping, the web and suspended blanks are next pulled to the blanking station, for separation into unattached box blanks and web portions for disposal. In particular, the stripped sheet is urged over the female blanking die portion. The sheet lies flush against the female blanking die surface. The male blanking die and attendant die members are pressed against the female die, with holders temporarily-engaging the sheet to prevent its movement, and the blanks are forced through the holes through the female cutting die and are separated from the web. Upon completion of the blanking operation, the carton blank is then pushed through proper sized holes in the female blanking die onto a pallet or stack, therebelow.

The blanking operation, thus, serves to separate the actual carton blanks from the suspending web portion using the upper male die/lower female die combination. The female blanking die includes a series of blanking holes, matching the profile of the die-cut lay-out of the blanked cartons. The female blanking die further provides support for the sheet or web as it crosses the upper faces of the female blanking die. The stamped sheet is supported by the female blanking die. In the operation of the blanking dies, the upper male die is pressed downward, with the holders temporarily-holding the sheet against movement, and through the corresponding through holes in the female die, thereby separating and pushing through the die-cut carton blanks through the corresponding through holes in the female die, and leaving the web on the surface of the female die.

It is then necessary automatically-to-remove the remaining web from the female die face portion by use of conventional travelling bar and grippers.

The following description now provides a full detailed description of the essential components which are used for the setting-up of the female blanking die of aspects of this invention.

The rail connector element 400 is shown in FIG. 4, FIG. 5, and FIG. 6. The rail connector element 400 is a generally inverted "L"-shaped member 401 including a reposed upper leg block 402 and a depending arm block 403.

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Upper reposed leg block 402 includes a through hole ⁸⁴⁰⁴404 extending from its front face ⁸⁴⁰⁵405 to its rear face 406. Depending arm block ⁸⁴⁰⁵403 includes a through hole 408 extending from its inner end face 409 to its outer end face 410.

5 In use, the rail connecting element 400 is placed at the inner intersection of a rear rail 202 and of a side rail 203, with the upper reposed leg block 402 against the internal dovetail groove 210 in the side rail 203 and the depending arm block ⁸⁴⁰³403 against the groove 210 in the rear rail 203. A suitable bolt 407, e.g., an Allen-head bolt, is inserted through the through hole 408 and is threaded into a trapezoidal nut 411 which is inserted in the internal dovetail groove 210 in the rear rail 202. Similarly, a suitable bolt ⁴⁰⁷407, e.g., an Allen-head bolt, is inserted through the through hole ⁸⁴⁰⁴404 and is threaded into a trapezoidal nut 411 which is inserted in the internal dovetail groove 210 in side rail 203. Complete tightening of the suitable bolts ~~404~~, 407, e.g., Allen-head bolts, secures the rear rail 202 to the side rail 203.

15 In a similar fashion, the remaining three intersecting corners are locked together. This provides a complete, rigid rectangular frame consisting of the universal press frame of the required dimensions.

FIG. 7 and FIG. 8 show an embodiment of the centre line orientation cylinders 700. Each centre line orientation cylinder 700 includes an upper barrel 701, which is provided with a diametrical through hole 702. The upper barrel 701 terminates in a lower threaded end 703. The lower threaded end 703 extends downwardly to an integral depending threaded base 704. An internally-threaded, disc-like, lock collar 705, which includes a plurality of circumferentially-arranged engagement nicks 706 and is threaded onto the terminal-threaded end 703 of the upper barrel 701.

25 As noted hereinabove, the template 100 is provided with a securement hole, e.g., now designated 707, for each of the front and rear centre line orientation cylinders 700, the securement hole, e.g., 707, being along the centre line 708 as provided by the CAD program. A "T"-nut 709 is secured within each hole 707. It is noted that the "T"-nut 709 includes a circular, disc-like base 710 from which an internally-threaded upright cylinder 711 extends. The circular, disc-like base 710 is provided with a plurality, e.g., 30 four, upwardly-projecting teeth 712. The "T"-nut 709 is secured to the template 100 by

inserting the internally-threaded upright cylinder 711 into the pre-drilled hole 707, in the template 100, and then is hammered "home", so that the upwardly-projecting teeth 712 project into the wood of the template 100, to secure the "T"-nut 709 to the template 100.

5 In use, the front and rear centre line orientation cylinders 700 are loosely-threaded into their associated "T"-nuts 709. When the through holes 702 are lined-up, the interiorly-threaded disc-like lock collar 705 is threaded to engage the top surface of the template 100 frictionally. The centre line orientation cylinders 700 are, thus, secured at that correctly-oriented position by means of interiorly-threaded disc-like lock collar 705. The cylindrical centre line rod 105 is then inserted through the through holes 702 to extend beyond the centre line orientation cylinders 700, as shown in FIG. 1.

10 FIGS. 9 to 13 show one embodiment of a centre line orientation bracket.

FIG. 9 shows the centre line orientation bracket 900. Each centre line orientation bracket 900 is generally of rectangular front and rear elevational appearance. The lower edge 901 is provided, in its interior face 902, with an upwardly-extending slot 903, and in its exterior face 904, with a similar, but larger countersunk slot 905. The upper edge 906 is provided with a semi-cylindrical cradle 907. One side edge ~~908~~ of the centre line orientation bracket 900 adjacent to its upper end is provided with an internally-threaded aperture 909, into which is threaded a suitable bolt 910, e.g., an Allen-head bolt. This suitable bolt 910, e.g., an Allen-head bolt, may be used to lock a cylindrical centre line rod ~~907~~ in the cradle ~~904~~, if desired.

20 ¹⁰⁵ The upper portion 911 of the centre line orientation bracket 900 is thicker than the lower leg 912 thereof. The slots 903, 905 are within the lower leg 912 of the centre line orientation brackets 900. The face 902 of the upper portion 911 includes a downwardly-depending flange 913 defining, between the inner edge 914 of the downwardly-depending flange 913 and the outer edge 915 of the lower leg 912, an attachment groove 916, which is adapted to fit into an upper flange 917 on the front rail 201 and the rear rail 202.

25 In use, two centre line orientation brackets 900, namely the front and rear centre line orientation brackets 900, are lowered onto a respective suitable bolt 208, e.g., an Allen-head bolt, which is loosely-threaded into an internally-threaded trapezoidal nut,

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which is slidably-retained within the dovetail-shaped internal groove 205 in the front rail 201 and the rear rail 202, respectively, so that they are slidably-secured to the front rail 201 and to the rear rail 202, respectively.

The so-placed front and rear centre line orientation brackets 900 are also placed so that their attachment grooves 916 fit into the corresponding upper flanges on the front rail 201 and the rear rail 202, respectively. The centre line orientation brackets 900 are then slid until they are disposed at the precise centre of the front rail 201 and of the rear rail 202, respectively. Then, the suitable bolts, e.g., Allen-head bolts, are completely-screwed into the internally-threaded trapezoidal nuts, whereby the front and rear centre line orientation brackets 900 are firmly-secured at the precise centre line of the universal press frame 200.

FIGS. 14 to 17 show views of the template corner locking clamp 1700. Each template corner locking clamp 1700 includes an upper "L"-shaped component 1701 and a lower "L"-shaped component 1750. The upper "L"-shaped component 1701 includes a horizontal plate 1702 which includes a closed-ended, race-track-shaped slot 1703 therethrough near its outer end, and a vertical depending leg 1704. The vertical depending leg 1704 includes a countersunk, longitudinally-extending threaded aperture 1705. The inner face of the vertical depending leg 1704 includes a longitudinally-extending channel 1706 therein.

The lower "L"-shaped component 1750 includes a horizontal arm 1751 which is provided with a longitudinally-extending, internally-threaded hole 1752 extending from its outer face, and a vertical depending leg 1753. The vertical depending leg 1753 includes a slit 1754 extending upwardly from the lower edge 1755 thereof, to provide a wide outer ledge 1756 and a narrow inner ledge 1757 defining a springingly-movable wall 1758. The outer face 1759 is provided with an internally-threaded hole 1760 extending completely transversely through the wide outer ledge 1756 and extending into the slit 1754.

In use, the template corner locking clamp 1700 is first assembled. This is done by placing the outer face ~~1752~~ of the lower "L"-shaped component 1750 into the longitudinally-extending channel 1706 of the upper "L"-shaped plate 1701. Then, a

suitable bolt 1707, e.g., an Allen-head bolt, is threaded through the countersunk, longitudinally-extending threaded aperture 1705 in the vertical depending leg ¹⁷⁰⁴ of the upper "L"-shaped plate 1701 fully into the countersunk, longitudinally-extending threaded aperture ¹⁷⁵² in the lower "L"-shaped component 1750.

5 Then, the assembled template corner locking clamp 1700 is dropped down to be placed atop a side rail 203 (shown in dot-and-peck), with the space between the inner face 1709 of the upper "L"-shaped component 1701 and the inner face 1761 of the lower "L"-shaped component 1750 providing an interference fit for the side rail 203. Then, a suitable bolt 1762, e.g., an Allen-head bolt, is threaded through the internally-threaded
10 hole 1760 in the lower "L"-shaped component 1750 until it abuts the inner face 1763 of the slit 1754.

The template corner locking clamp 1700 is then slid along the side rail 203 to the appropriate pre-determined datum position, as defined by the CAD program. The suitable bolt 1762, e.g., the Allen-head bolt, is then completely-tightened, to provide a
15 secure frictional engagement between the template corner locking clamp 1700 and the side rail 203.

Incidentally, FIG. ¹⁵ also shows the internal dovetail groove 210 in the side rail 203, and a trapezoidal nut 1770 with an internally-tapped hole 1771 therein.

FIG. 19 and FIG. 20 show views of the legs 2100 which are used to support the
20 front rail 201 and the rear rail 202 of the universal press frame 200. Each of the legs 2100 is a generally-square, rectangular parallelepiped block 2101, with a longitudinally-extending channel 2102 extending downwardly from the top face 2103 thereof. An interior ledge 2104 is provided adjacent to an interior face 2105 of the block 2101. A longitudinally-extending slot 2106 is provided adjacent to the outer face of the block, to
25 provide an exterior ledge 2108 and an intermediate, springingly-movable wall 2109. The outer face 2107 of the block 2101 is provided with an internally-threaded through hole 2110, into which is threaded a suitable bolt 2111, e.g., an Allen-head bolt.

In use, the front rail 201 or the rear rail 202 is inserted downwardly into the longitudinally-extending channel 2102. The relative dimensions of the longitudinally-
30 extending channel 2102 and of the rails 201,202 are such that there is an interference fit

therebetween. However, to lock the rails 201,202 to each leg 2100, the suitable bolt 2111, e.g., the Allen-head bolt, is screwed into contact with a hidden face 2112 of the intermediate, springingly-movable wall 2109. Continued screwing springingly-deforms the intermediate, springingly-movable wall 2109 to cause a greater frictional engagement between the rails 201,202 and the associated leg 2100.

FIGS. 21 to 23 show views of a preferred embodiment of a side rail jogger member 2300 and/or rear rail jogger member 2300. Such jogger member 2300 includes a main upright base 2301, an adjustable support member 2355 and a guiding member 2365.

10 Main upright base member 2301 is a generally-rectangular plate 2302, having parallel side faces ~~2303~~ ^{one of which is represented as} 2304 providing an interior face and an exterior face respectively, as well as an upper edge 2305 and a lower edge 2306. The upper edge 2305 is provided with downwardly-depending slot 2307, which provides an inner block-like portion 2308, and an outer block-like portion 2309. The outer block-like portion

15 2309 is provided with a transverse, internally-threaded hole 2310, extending through to the slot 2307, into which is threaded a suitable bolt 2311, e.g., an Allen-head bolt.

The lower end 2312 of the main upright base member 2301 is provided with an upwardly-extending notch 2313, into which is secured a dovetail block 2314, whose structure will be described hereinafter, by means of a suitable bolt ²³¹⁵ ~~2311~~, e.g., an Allen-head bolt, which is threaded into an internally-threaded aperture 2316 in the interior face 2317 of the notch 2313.

20 The dovetail block 2314 is a two-piece, generally-rectangular, parallelepiped block, which is constituted by a major fixed piece 2319 and a minor, movable piece 2320. The major piece 2319 is a block having an upper roof 2321, an inner wall 2323 ^{having} ~~including~~ an inner face ~~2325~~, an outer face 2324 and a minor roof 2325. The lower edge of block 2319 is flush with the lower edge 2306 of the lower end 2312 of the main upright base member 2301. The outer face 2324 includes a major floor 2326, terminating in a downwardly-extending projection 2327 which constitutes the lower half of a dovetail 2328. The upper edge 2329 of the lower half of the dovetail 2328 is flush

30 with floor 2340. The minor roof 2325 is provided with a downwardly-depending flange

CLAIMS

1. [AMENDED] A jogger member for use in erecting a universal press frame for a female blanking die for a die cutting machine for die cutting and/or blanking a carton blank, said universal press frame including a rectangular framework of connecting rails [~~comprising two side rails, a front rail and a rear rail~~] on which [~~a plurality of jogger members which are selectively disposed~~] said jogger member is disposed within an internal groove in one of said connecting rails and along an [the] interior perimeter of said rectangular framework, said jogger member comprising:

- B1
- a) a base member;
 - b) means which are [~~operatively-associated~~] operatively associated with said base member for selectively [~~-, but rigidly,-~~] securing said jogger member to the interior perimeter of said rectangular framework;
 - c) an adjustable support member which is adjustably [-] and slidably [-] disposed with respect to said base member; and
 - d) a guiding member having an upper edge and a lower edge, said guiding member being secured to a [one] face of said adjustable support member to provide a depending guiding face for guidance of said jogger member within an internal groove of said rectangular framework.

2. [CANCELLED]

3. [AMENDED] The jogger member as claimed in claim 1 [2], wherein said rail is provided with an internal groove having an upper flange and a lower flange defining said internal groove, and wherein said means (b) comprises an inwardly-directed slot by which [~~by means of which~~] said jogger member is [~~may be~~] adjustably [~~attached~~] attachable to said rail by a screw or a bolt. [~~rails of said rectangular framework by means of screws or bolts.~~]

4. [AMENDED] The jogger member as claimed in claim 3 [2], wherein said means (b) comprises a transverse plate of a dimension enabling said jogger member [it] to cooperate with said rails of said rectangular framework, said transverse plate including at least one tapped hole into which a bolt or screw may be threaded to engage said rail of said rectangular framework.

5. [AMENDED] The jogger member as claimed in claim 3 [2], including a slidable captive cap [means] having a leading edge, said ~~[slidable captive cap means]~~ cap being slidably [-] secured to said guiding member for selective disposition of said [its] leading edge a predetermined cantilevered distance over said guiding face of said guiding member.

6. to 13. [CANCELLED]

14. [AMENDED] The jogger member as claimed in claim 3 [2], wherein said guiding member includes a supplemental guiding finger having an upper end and a lower end, said supplemental guiding finger being slidably [-] associated with said guiding face of said guiding member, said supplemental guiding finger being slidable between (a) a position in which a lower edge of said guiding finger is flush with a [said] lower edge [end] of said guiding member and (b) a position where said guiding finger [it] extends below said lower edge of said guiding member.

15. [AMENDED] The jogger member as claimed in claim 14, wherein said supplemental guiding finger includes a longitudinally-extending slot, and wherein said guiding member includes a bolt ~~[means which is secured]~~ for securing to said guiding member and which projects into said longitudinally-extending slot to limit said extent of movement of said supplemental guiding finger within said longitudinally-extending slot.

16. [AMENDED] The jogger member as claimed in claim 15, wherein said guiding face of said guiding member includes a longitudinally-extending slot within which said supplemental guiding finger is guided to slide, and wherein said supplemental guiding finger is

provided with a pair of parallel lateral complementary flanges, whereby said longitudinally-extending slot of said guiding member and said pair of parallel lateral complementary flanges [thereby] cooperate to hold said supplemental guiding finger within said longitudinally-extending slot [as well as] of said guiding member, and to provide a slideway for said supplemental guiding finger with respect to said guiding member.

17. [AMENDED] The jogger member as claimed in claim 5, wherein said slidable captive cap includes a longitudinally-extending slot, wherein a screw [means] is disposed in said slot and is threadedly [-] secured to said upper edge of said guiding member to hold said slidable captive cap to said guiding member, and [as well as] to secure said slidable captive cap in [its] a selected cantilevered position, and

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said guiding member includes a supplemental guiding finger having an upper end and a lower end, said supplemental guiding finger being slidably [-] associated with said guiding face of said guiding member, said supplemental guiding finger being slidable between a position in which [its] a lower edge of said finger is flush with a [said] lower [end] edge of said guiding member and a position where said finger [it] extends below said lower edge of said guiding member.

18. to 23. [CANCELLED]

24. [AMENDED] The jogger member as claimed in claim 1 [18], wherein said connecting rails are each provided with an internal dovetail-shaped groove which defines said internal groove, and wherein said guiding member includes a supplemental guiding finger having an upper end and a lower end, said supplemental guiding finger being slidably [-] associated with said guiding face of said guiding member, said supplemental guiding finger being slidable between a position in which a [its] lower edge of said guiding finger is flush with a lower edge [said lower end] of said guiding member and a position where said guiding finger [it] extends below said lower edge of said guiding member.

25. [AMENDED] The jogger member as claimed in claim 24, wherein said supplemental guiding finger includes a longitudinally-extending slot, and wherein said guiding member includes a bolt [means] which is secured to said guiding member and which projects into said longitudinally-extending slot of said guiding finger to limit the extent of movement of said supplemental guiding finger within said longitudinally-extending slot.

26. [AMENDED] The jogger member as claimed in claim 24, wherein said guiding face of said guiding member includes a longitudinally-extending slot within which said supplemental guiding finger is guided to slide, and wherein said supplemental guiding finger is provided with a pair of parallel lateral complementary flanges, whereby said longitudinally-extending slot and said pair of parallel lateral complementary flanges [thereby] cooperate to hold said supplemental guiding finger within said longitudinally-extending slot and [as well as cooperating to] provide a slideway for said supplemental guiding finger with respect to said guiding member.

27 to 31. [CANCELLED]

32. [AMENDED] The jogger member as claimed in claim 1 [18], wherein said connecting rails are each provided with an internal dovetail-shaped groove defining said internal groove, said member including: (e) a slidable captive cap [means] having a leading edge, said slidable captive cap [means] being slidably [-] secured to said guiding member (d) for selective disposition of [its] said leading edge a predetermined cantilevered distance over said guiding face of said guiding member.

33. [AMENDED] The jogger member as claimed in claim 32, wherein said slidable captive cap includes a longitudinally-extending slot, and including a screw [means] which is disposed in said slot and which is threadedly [-] secured to said upper edge of said guiding member to hold said slidable captive cap in a [its] selected cantilevered position.

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34. [AMENDED] The jogger member as claimed in claim 32, wherein said slidable captive cap [means] includes a longitudinally-extending slot, and including a screw [means] which is disposed in said slot of said cap and which is threadedly [-] secured to said upper edge of said guiding member to hold said slidable captive cap to said guiding member as well as to secure said slidable captive cap in a [its] selected cantilevered position.

35. to 67. [CANCELLED]